

Date: Tuesday, 12/02/2008 2:28:55 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LID PRO ARM ASSEMBL. (SHORT)	
Job Number	: 37387		Part Number	: D2332041	
Estimate Number	: 10258		Drawing Number	: D2332	
P.O. Number	:		Project Number	: N/A	
This Issue	: 12/02/2008 S.O. No. :		Drawing Revision	: C	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 19/02/2008 Qty: 12 Um: Each	
Previous Run	: 36849			R	
Written By:	:				
Checked & Approved By	:				
Comment	: Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/ RF				

Additional Product

~~* Scrap Pt~~

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR1000WO49	304 RD Tube 1.0" x .049W	
		Comment: Qty.: 0.4331 f(s)/Unit Total : 5.1975 f(s) Material: 1.000" OD x 0.049" wall SS Tube (Seamless)	Batch M105260 SB 08/03/07 (12)
2.0	M304R250	1/4" 304 SS Roundbar	
		Comment: Qty.: 0.1092 f(s)/Unit Total : 1.3104 f(s) Material: Ø0.250" 304SS Rod	Batch M105150 SB 08/03/07 (12)
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar	
		2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin	
		3-Deburr	
4.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 1.2502 f(s)/Unit Total : 15.0024 f(s) 304 RD Tube .500 x .035W	
		M106015 (14) M106593 (16) M107098 (17)	
		M104880 (1) + 2 /	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/02/2008 2:28:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 37387

Part Number: D2332041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012

(Note: Make (2) D2332-11 Prop Arms per assembly.)

SB 08/04/12

29

10

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)

BB/03/06 12

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

12 x

A/R SS Rod Batch: M106593 M 107051 08-04-24.

sp.

PTO

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

10.0 AN44A Bolt



SCH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

1 AN4-4A

Description

Bolt

Batch

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2332-041 PAR #: N/A Fault Category: Prod Fas Large NCR: Yes No DQA: Date: 08/04/29
 QA: N/C Closed: Date: 08/04/29

NCR: 37387		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/24	#	During welding inspection it was found that there is a foreign object inside the Prop Arm.	<input checked="" type="checkbox"/> 08/04/24	ADD step to ensure there is no foreign object prior to welding	<input checked="" type="checkbox"/> 08/04/24	<input checked="" type="checkbox"/> 08/04/24	<input checked="" type="checkbox"/> 08/04/24	<input checked="" type="checkbox"/> 08/04/24
		PC welder did not check for a foreign object prior to welding	<input checked="" type="checkbox"/> 08/04/24	Scrap and destroy all 12 parts. all 12 parts	<input checked="" type="checkbox"/> 08/04/24	<input checked="" type="checkbox"/> 08/04/24	<input checked="" type="checkbox"/> 08/04/24	<input checked="" type="checkbox"/> 08/04/24

NOTE: Date & initial all entries

Date: Tuesday, 12/02/2008 2:28:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 37387

Part Number: D2332041

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 AN960JD416L Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN960JD416L	Washer	_____

12.0 MS21042L4 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21042L4	Nut (or -4)	_____

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

15.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

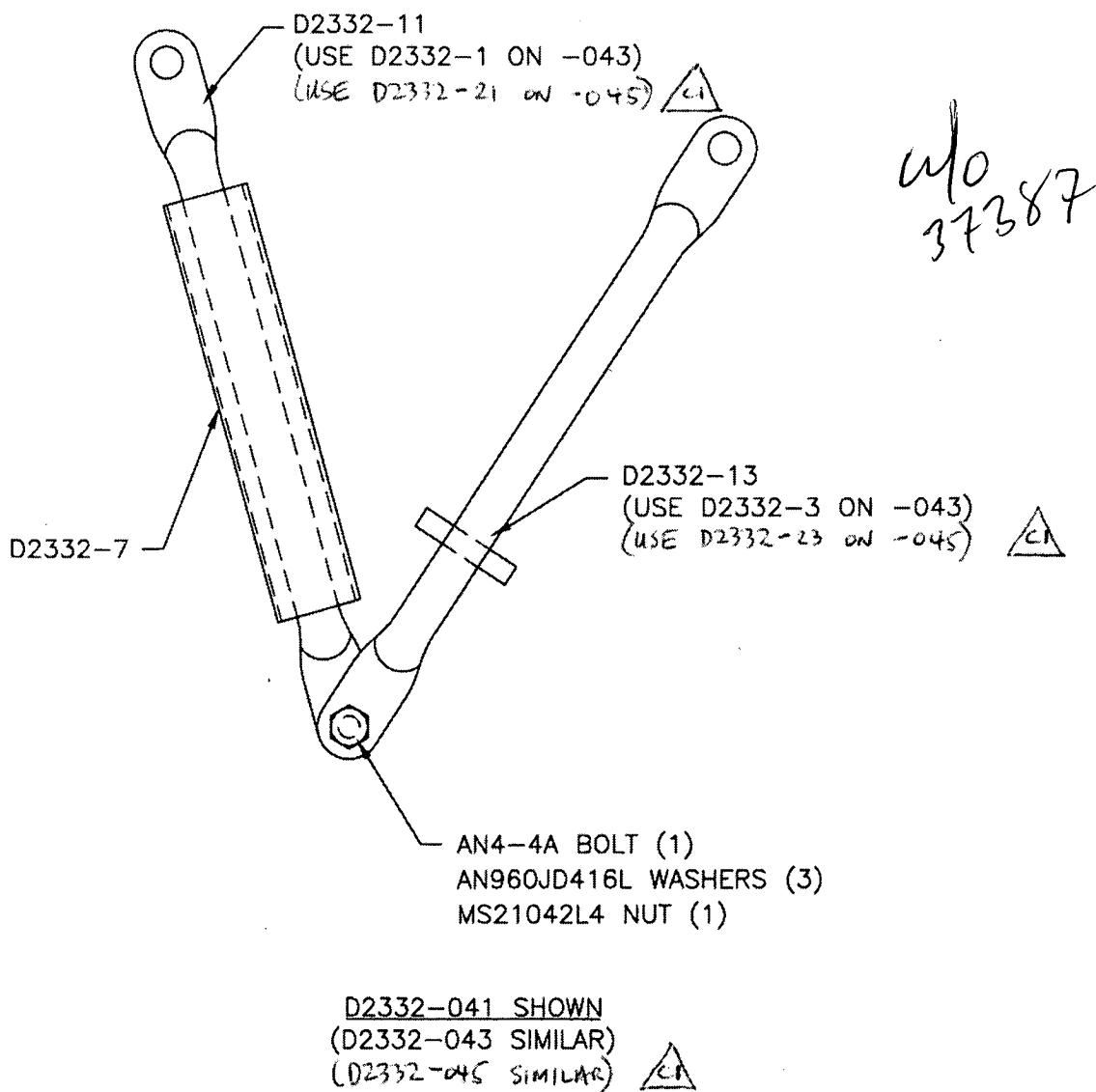
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2332	SHEET 1 OF 2
DATE		TITLE	SCALE
03.07.03		LOD PROP ASSEMBLY	NTS

RELEASER
03.07.04

A	94.12.16	NEW ISSUE
B	97.09.30	CHANGE 416 WASHERS TO 416L
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)
C1	03.08.06	ADD -045 PROP (7.25" LONG)



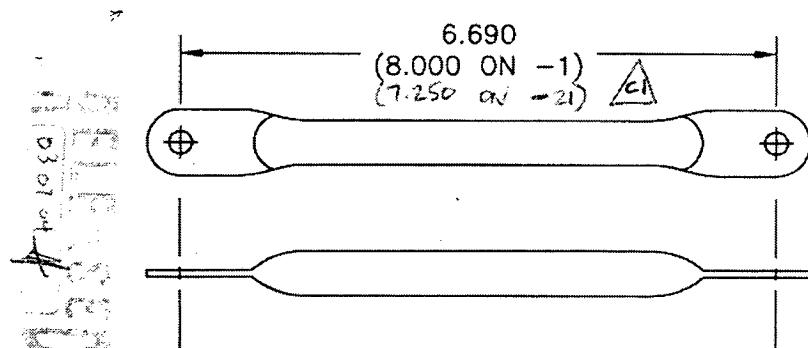
Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

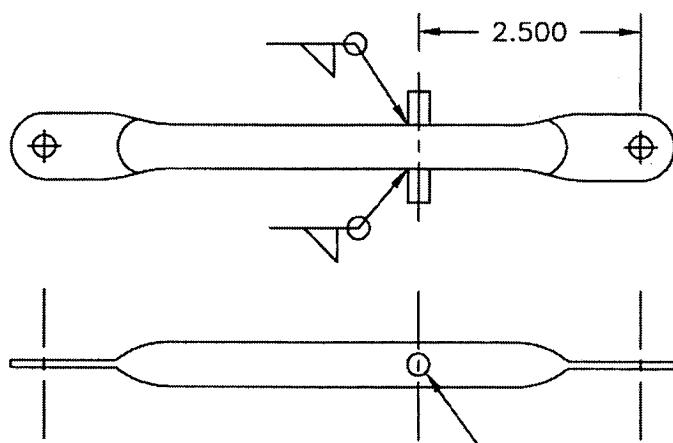
DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
DATE	APPROVED	REV. C
TITLE	SHEET	
03.07.03		2 OF 2
C	03.07.03	MATERIAL - 0.5 OD PROPS 6.690" LONG (4RD) MATERIAL - 0.25 OD ROD 1.25 LONG (D2332-5) M303R0.250 MATERIAL - 1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049 ADD - 045 PROPS (1.25" LONG)
C1	03.08.03	

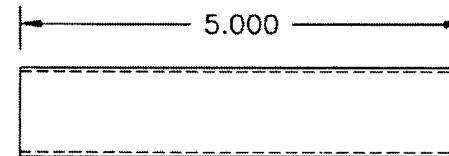


D2332-11 PROP
(D2332-1 SIMILAR)



D2332-13
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)



D2332-7 LOCKING COLLAR

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13